

Work Order ID 131358-1

131358

Page 1

April-06-15 10:39:45 AM

Item ID: D3537-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearpad

Start Date: 4/06/15 Start Qty: 60.00

60

Cust Item ID:

Required Date: 4/17/15 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3537

D

110

0.00

110

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut D3537-1 as per Dwg D3537

Dwg Rev: D

Prog Rev: D

2-Deburr if necessary

(66) _____ 04/15/06

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

(66) _____ 04/15/06

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APR 14 4 45 PM 2011

1000

Work Order ID 131358

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Page 3

April-06-15 10:39:45 AM

Item ID: D3537-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearpad

Start Date: 4/06/15 Start Qty: 60.00

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Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 Weld per dwg A/R Hardcoat S.S. Batch: M131090 0.00

160

Large Fab

Memo

0.00

Large Fab

A/R 2059B Hardcoat BATCH: M131090

x28

15-04-16 MAL

170 QC10- Inspect visual per QSI004- ground welds 0.00

170

QC

Memo

0.00

Quality Control

28

DAS

38

ADD 16 2015

180 QC5- Inspect part completeness to step on W/O 0.00

180

QC

Memo

0.00

Quality Control

28

DAS

38

9-89

APR 16 2015

400 3 144

Work Order ID 131358

131358

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April-06-15 10:39:45 AM

Item ID: D3537-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearpad
 Start Date: 4/06/15 Start Qty: 60.00 *60* Cust Item ID:
 Required Date: 4/17/15 Req'd Qty: 60.00 *60* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: <u>PO-0d</u>	0.00							
210									
Packaging	Memo	0.00							
Packaging									
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

28 x d Hl 15/04/16

MLS 15-04-20

MF
15-4-17

Picklist Print

April-06-15 10:39:45 AM

Page 1

Work Order ID: 131358

131358

Parent Item: D3537-1

D3537-1

Parent Item Name: Wearpad

Start Date: 4/06/15

Required Date: 4/17/15

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA

Purchased

No

100

sf

441.0176

0.106

7

M304S16GA

Q 15-4-7

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT019

441.0176

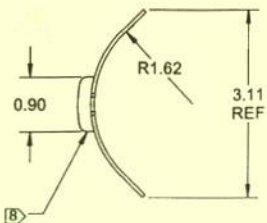
m131384

182.0176

m131503

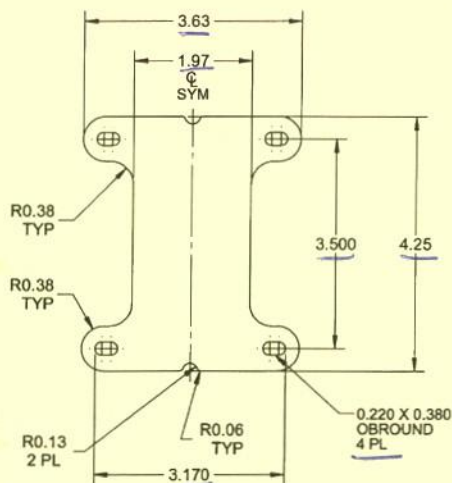
259

9



D3537-1 WEARPAD
(MAKE FROM D3537-1F)

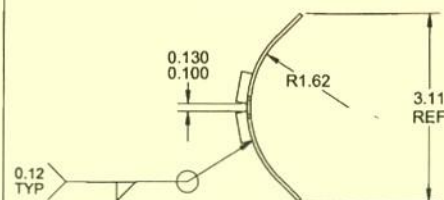
0.25
TYP



D3537-1F FLAT PATTERN

NOTES:

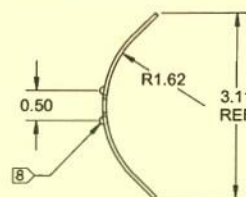
- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED, 16 GAUGE (0.063) PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 PER DART SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-1" PER QSI 044 6.1 (PERMANENT MARKER)
- 7) WEIGHT: 0.42 lbs
- 8) APPLY 2 LAYERS OF 2059B HARDCOAT WELD TO WITHIN 0.25 OF WEARPAD ENDS, 0.19 TO 0.25 THICK
- 9) WELDING: PER QSI 004



D3537-5 WEARPAD
(MAKE FROM D3537-1F)

NOTES:

- 1-5) AS PER D3537-1
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-5" PER QSI 044 6.1 (PERMANENT MARKER)
- 7) WEIGHT: 0.42 lbs
- 8) APPLY 2 LAYERS OF 2059B HARDCOAT WELD TO WITHIN 0.25 OF WEARPAD ENDS, 0.19 TO 0.25 THICK
- 9) WELDING: PER QSI 004



D3537-9 WEARPAD
(MAKE FROM D3537-1F)

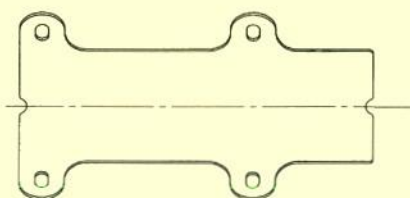
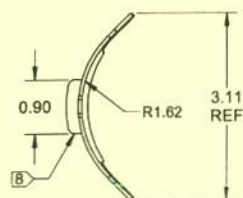
NOTES:

- 1-5) AS PER D3537-1
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-9" PER QSI 044 6.1 (PERMANENT MARKER)
- 7) WEIGHT: 0.19 lbs
- 8) APPLY 2059B HARDCOAT WELD BEAD, 0.06 TO 0.13 THICK ON BOTTOM SURFACE, AFTER FORMING
- 9) WELDING: PER QSI 004
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.02-0.04 THICK, PER DART QSI 005 4.9

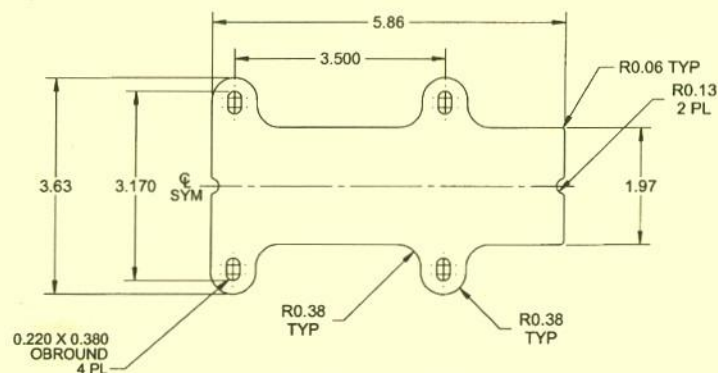
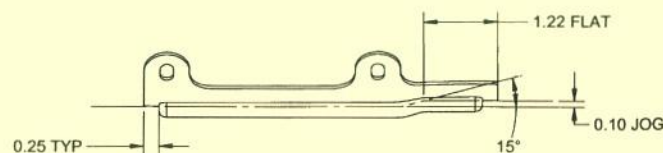
D	RE-FORMAT DRAWING, ADD -9-11 WEARPADS	DB	14.10.16
C	WIDEN TAB TO 0.380, WELD PATTERN	CB	07.04.13
B	ADD AMS 5513 AND AMS 5524	CB	07.03.20
A	NEW ISSUE	CB	06.11.06
REV.	DESCRIPTION	BY	DATE

DESIGN	CB	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	DB		
CHECKED	DW	DRAWING NO.	REV. D
MFG. APPR.	DD	D3537	SHEET 1 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	WEARPAD	NTS
DATE	14.10.16	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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2014-11-05



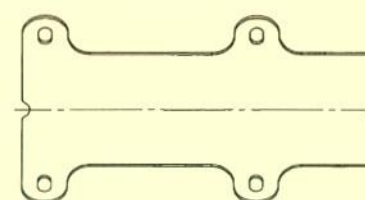
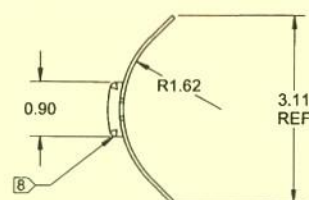
D3537-3 WEARPAD
(MAKE FROM D3537-3F)



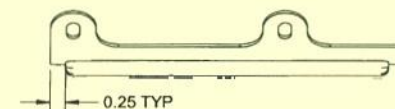
D3537-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED, 16 GAUGE (0.063) PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 PER DART SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-3" PER QSI 044 6.1 (PERMANENT MARKER)
- 7) WEIGHT: 0.50 lbs
- 8) APPLY 2 LAYERS OF 2059B HARDCOAT WELD TO WITHIN 0.25 OF WEARPAD ENDS, 0.19 TO 0.25 THICK
- 9) WELDING: PER QSI 004

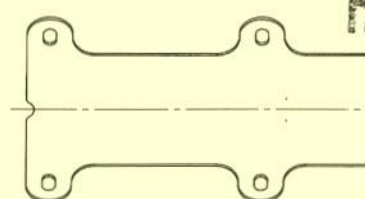
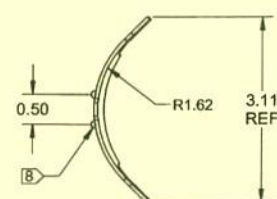


D3537-7 WEARPAD
(MAKE FROM D3537-3F)

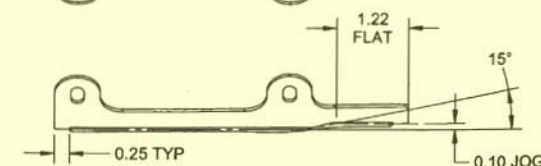


NOTES:

- 1-5) AS PER D3537-3
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-7" PER QSI 044 6.1 (PERMANENT MARKER)
- 7) WEIGHT: 0.50 lbs
- 8) APPLY 2 LAYERS OF 2059B HARDCOAT WELD TO WITHIN 0.25 OF WEARPAD ENDS, 0.19 TO 0.25 THICK
- 9) WELDING: PER QSI 004



D3537-11 WEARPAD
(MAKE FROM D3537-3F)



NOTES:

- 1-5) AS PER D3537-3
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-11" PER QSI 044 6.1 (PERMANENT MARKER)
- 7) WEIGHT: 0.25 lbs
- 8) APPLY 2059B HARDCOAT WELD BEAD, 0.06 TO 0.13 THICK ON BOTTOM SURFACE, AFTER FORMING
- 9) WELDING: PER QSI 004
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.02-0.04 THICK, PER DART QSI 005 4.9

APPROVED

DESIGN	DB
DRAWN	DB
CHECKED	DW
MFG. APPR.	DD
APPROVED	MP
DE APPR.	DS
DATE	14.10.16

DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO.	REV. D
D3537	SHEET 2 OF 2
TITLE	SCALE
WEARPAD	NTS

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